

Date: Tuesday, 16/01/2007 9:56:53 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 30285	
Estimate Number : 12643	
P.O. Number : N/A	Part Number : G106071
This Issue : 16/01/2007 S.O. No. : N/A	Drawing Number : G10607 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 26/01/2007 Qty: 10 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev:A New Issue 07-01-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1892 sf(s)/Unit Total: 1.8921 sf(s)

2024-T3 .050 sheet

\*\*\*\*\*Grain must Run Along 8.59" Dim \*\*\*\*\*

Batch: m 103210

m 07 01 16

(10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg G10607

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

\*\*\*\*\*Use same cutting file for -1 & -2 \*\*\*\*\*

m 07 01 16

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 07 01 16

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

m 07/01/17 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/10/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/01/2007 9:56:54 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 30285

Part Number: G106071

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS PER DWG G10607,

\*\*\*\*NOTE:-1 & -2 ARE C'SINKED ON OPPOSITE SIDES\*\*\*\*

FF 07-01-18 10

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/01/19 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

251 YL 07/01/22 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/22 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/01/22 (10)

07/01/22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22

Job Completion



11 07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

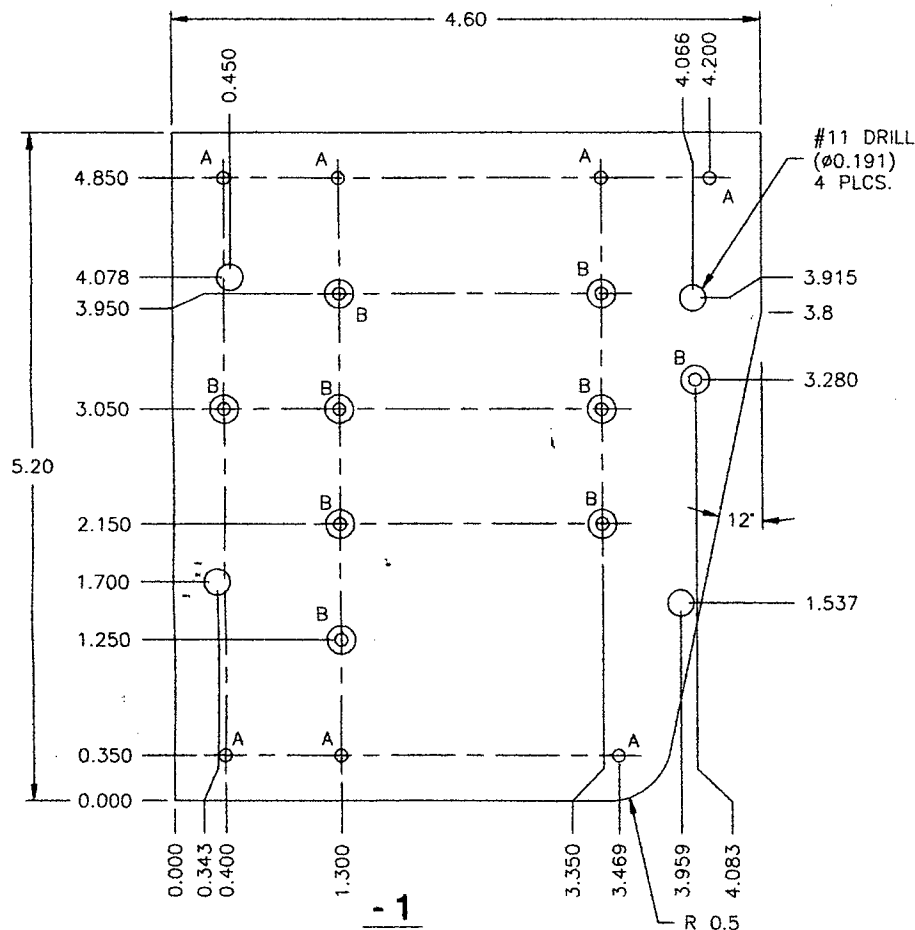
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Stephen Cichofsky  
253-395905

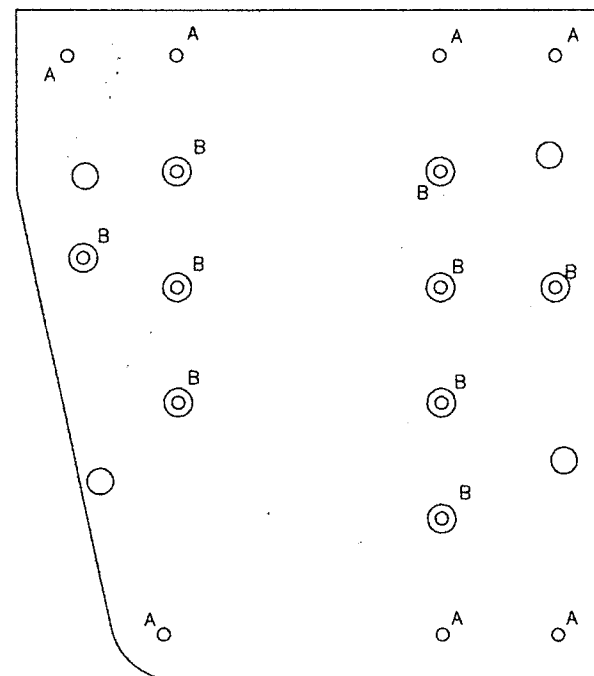


# NOTES:

## UNLESS OTHERWISE NOTED.


1. MAT'L: ALUM 0.050 THICK, 2024-T3.
2. ALL "A" AND "B" HOLES ARE #40 DRILL ( $\phi 0.098$ ), TO BE DRILLED TO SIZE AT ASSEMBLY.
3. COUNTERSINK 100° (NEAR SIDE) "B" HOLES FOR RIVETS MS20426AD-4 ( $\phi 0.221$ )
4. FINISH: ETCH, ALODINE PER MIL C5541-1A,

REVISION			
REV	DESCRIPTION	DATE	APPROV.
A	- ENLARGE ITEM -2 PICTORIAL FOR CLARIFY. - UPDATE DRAWING DIMENSIONS AND NOTES. - ECO 1038.	4/9/01	



-2

-2 SAME AS -1 EXCEPT "B" HOLES  
C'SK NEAR SIDE

BREAK ALL EDGES	✓	DRAWN	T.S.	DATE	3/25/95		GENEVA AVIATION			
UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES		CHECK		DATE			10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX(425)347-7100			
DIMENSIONAL TOLERANCES		DESIGN		DATE			TITLE DOUBLER DETAIL			
3 DECIMALS $\pm .010$ 2 DECIMALS $\pm .020$ 1 DECIMAL $\pm .050$ ANGULAR $\pm 1^\circ$		APPROVAL	RGC	DATE	4-3-95		DWG NO. G10607 PRO NO. GA159			
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.						SCALE		1/1	SHT.	1 OF 1
						REV.		A		

# FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

Measured by:	<i>MC</i>	Audited by:	<i>DA</i>	Prototype Approval:	<i>N/A</i>
Date:	<i>07/01/17</i>	Date:	<i>07/01/17</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHIP TO: DATE: 12/12/07 REF: 4062914					
SOLD TO: DATE: 12/12/07 REF: 4062914					
CUSTOMER PO NUMBER: N18187		WORK PACKAGE:		CUSTOMER PART NUMBER:	
Kaiser Order NO: 1033832		LINE ITEM: 1		SHIP UNLOAD ID: 100880/10	
WEIGHT SHIPPED: 7885 LB		SHIP DATE: 24-MAR-2008		ALLOY: 2024	
QUANTITY: 223 PCS EST.		M/L NUMBER: 207855		CLAD: CLAD	
		GAUGE: 0.0800 IN		TEMPER: T3	
				WIDTH: 48.000 IN	
				LENGTH: 144.000 IN	

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2598

## CERTIFIED TEST REPORT

Serial Number  
4062914

### Certified Specifications

AMS 4041/RevP  
BATS 2505/RevNC

AMS QQ-A-280/5/RevA  
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

### Test Results

Lot: 350042A8 Cast 318

Drop 16

Ingot 2

Tensile:	Temper	Dt / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	63.9 : 64.7 ✓ (441 : 445)	44.8 : 45.8 ✓ (309 : 318)	15.2 : 11.8 ✓

MRS Deflection: 0.017 IN

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.24	4.57	0.58	1.40	0.01	0.13	0.02	0.01	0.01	0.04

### ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.05	0.03	0.05	0.00	TOT	0.00

Aluminum Remainder

### TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS) CHEMICAL  
MILLING QUALITY (CMQ) REQUIREMENTS.

